



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G09132-3G-PO

Job Sheet 183474



Part No: RBW6205G09132-3G-PO **Job Qty:** 2 ea

Part Name: Trolley Adapter, Swashplate Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/9/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G09132-3G Rev 3 IPP Rev A outsource 18.09.18 DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs		10/9/18	0.00	0.00	Purchasing		OCT 09 2018
110	Packaging	2 pcs		10/9/18	0.00	0.00	Packaging2		OCT 09 2018
120	QC	2 pcs		10/9/18	0.00	0.00	QC6		38
130	Small Fab	2 pcs		10/9/18	0.00	1.00	Small Fab-4		MCC 9-89 DAS
140	QC	2 pcs		10/9/18	0.00	0.00	QC5		OCT 09 2018 68
150	Packaging	2 pcs		10/9/18	0.00	0.00	Packaging3-1		21 OCT 9-89
160	QC21-FG	2 Ea		10/9/18	0.00	0.00	QC21		33 OCT 11 2018

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: 040154 MANUFACTURE RBW6205G09132-3G AS PER Descriptions: DWG -Certificate of conformity is required

130 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into RBW6205G09132-3G. 3-Install placard using drive screws. .

040154 x2 SEP 18 2018 h h

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G09132-3GP	Trolley Adapter, Swashplate Support	2 pcs (1 ea)	100-Purchasing	5116647
91654A076 52	#2 Drive Screw	8 Ea (4 ea)	130-Small Fab	5015391
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	130-Small Fab	5021040

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G09132-3GP	2	0	0
130-Small Fab	91654A076	8	91	0
	RB41011	2	778	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S116648



Part: RBW6205G09132-3G

Job No: 183474

Serial No/Batch: S116648

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 10/09/18

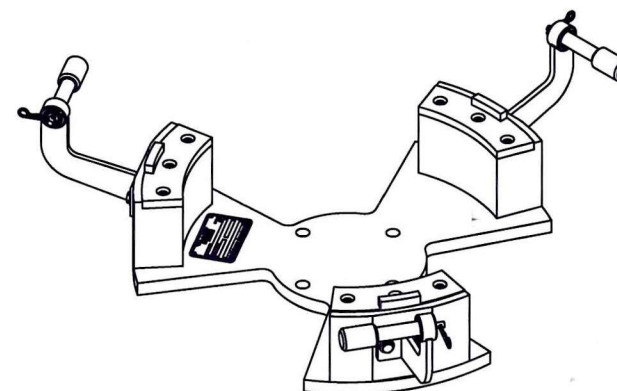
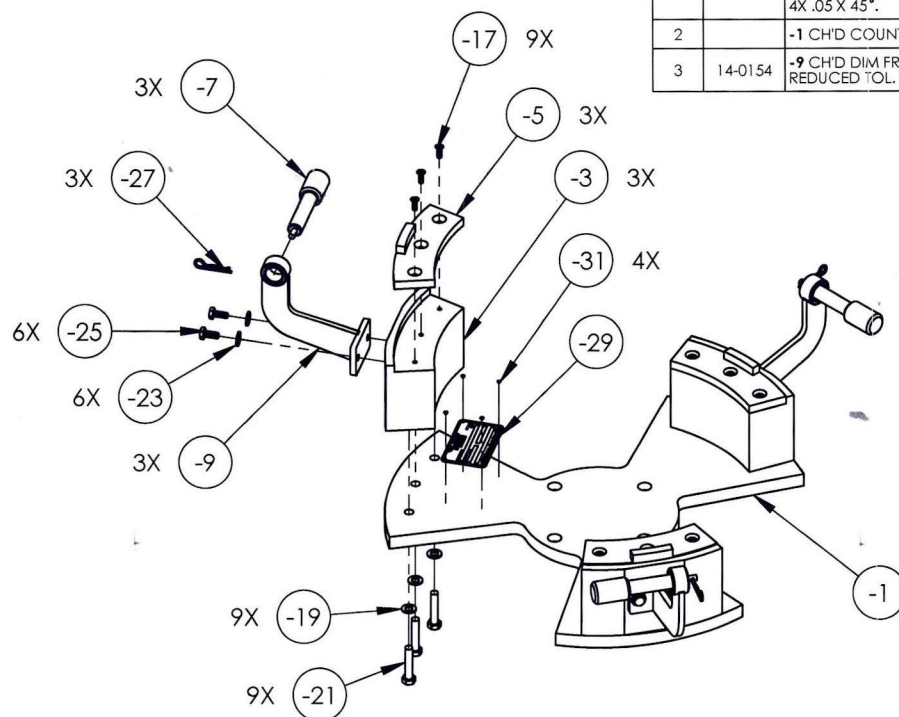
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Id not be found.

Plex 9/18/18 2:55 PM dart.Lussier.Patrick

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 CH'D COUNTERBORE WAS .594 ∇ .390 IS .594 ∇ .39. -3 CH'D HOLE DEPTHS WAS .394 IS .39, WAS 1.000 IS 1.00, WAS .625 IS .63. -7 ADDED NOTE "CENTER OK". -13 CH'D CHAMFER WAS 4X .050 X 45° IS 4X .05 X 45°.	6/25/2013	BIM	GE
2		-1 CH'D COUNTERBORE HOLES FROM $\varnothing$ 5.375 B.C. TO $\varnothing$ 5.512 B.C.	7/19/2013	RJC	RW
3	14-0154	-9 CH'D DIM FROM 4.164 TO 3.92. -11 CH'D DIM FROM 4.562 TO 4.32. UPDATE TITLE BLOCK TO DART, REDUCED TOL. ON NON-CRITICAL DIMS.	9/19/2014	JAG	DW



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	6061	5/8 X $\varnothing$ 18-3/4	2
			-3	3	BLOCK	6061	2-3/8 X 3-5/8 X 6-3/8	3
			-5	3	WEAR PLATE	WHITE NYLON	1 X 2-5/16 X 6-1/8	4
			-7	3	PIN	6061	$\varnothing$ 1 X 4-3/4	5
	X		-9	3	ARM WELDMENT			6
	1		-11		ARM	1018	1/4 X 4-1/4 X 4-1/2	7
	1		-13		RING	1018	$\varnothing$ 1-3/16 X 7/8	8
	1		-15		PLATE	1018	3/8 X 1-5/8 X 2-1/2	9
		B/O	-17	9	FLATHEAD SCREW	STEEL	M5 X .8 X 14mm MCMaster-CARR #91420A324	1
		B/O	-19	9	WASHER	STEEL	M8 MCMaster-CARR #91166A270	1
		B/O	-21	9	SCREW	STEEL	M8 X 1 X 40mm MCMaster-CARR #91180A540	1
		B/O	-23	6	WASHER	STEEL	1/4 MCMaster-CARR #90126A029	1
		B/O	-25	6	SCREW	STEEL	1/4-20 X 5/8 MCMaster-CARR #92620A539	1
		B/O	-27	3	HAIRPIN COTTER PIN	STEEL	MCMaster-CARR #98335A058	1
		B/O	-29	1	DART PLACARD	ALUMINUM	RB41011	1
		B/O	-31	4	#2 DRIVE SCREW	COATED STEEL		1
	ASSY -9							

NOTE:
ENGRAVE -29 PLACARD WITH T/N, S/N, "MADE IN USA".



TITLE
TROLLEY ADAPTER, SWASHPLATE SUPPORT

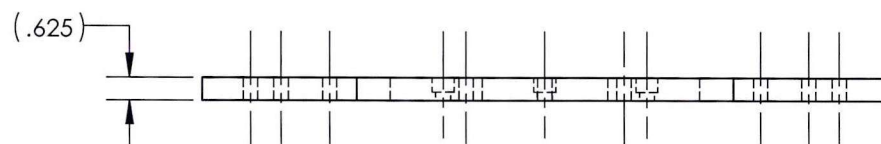
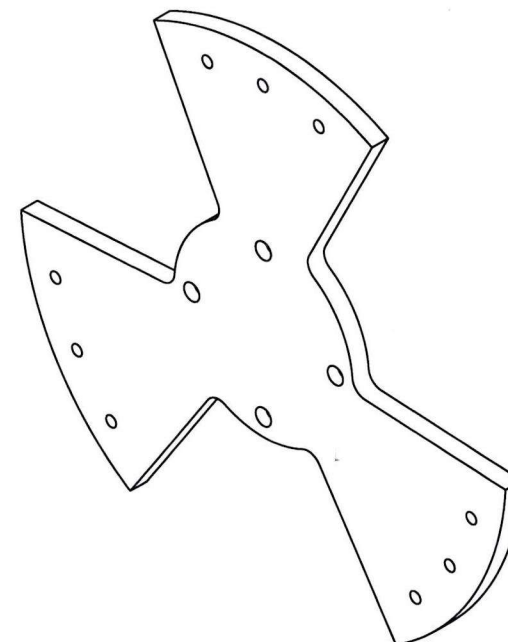
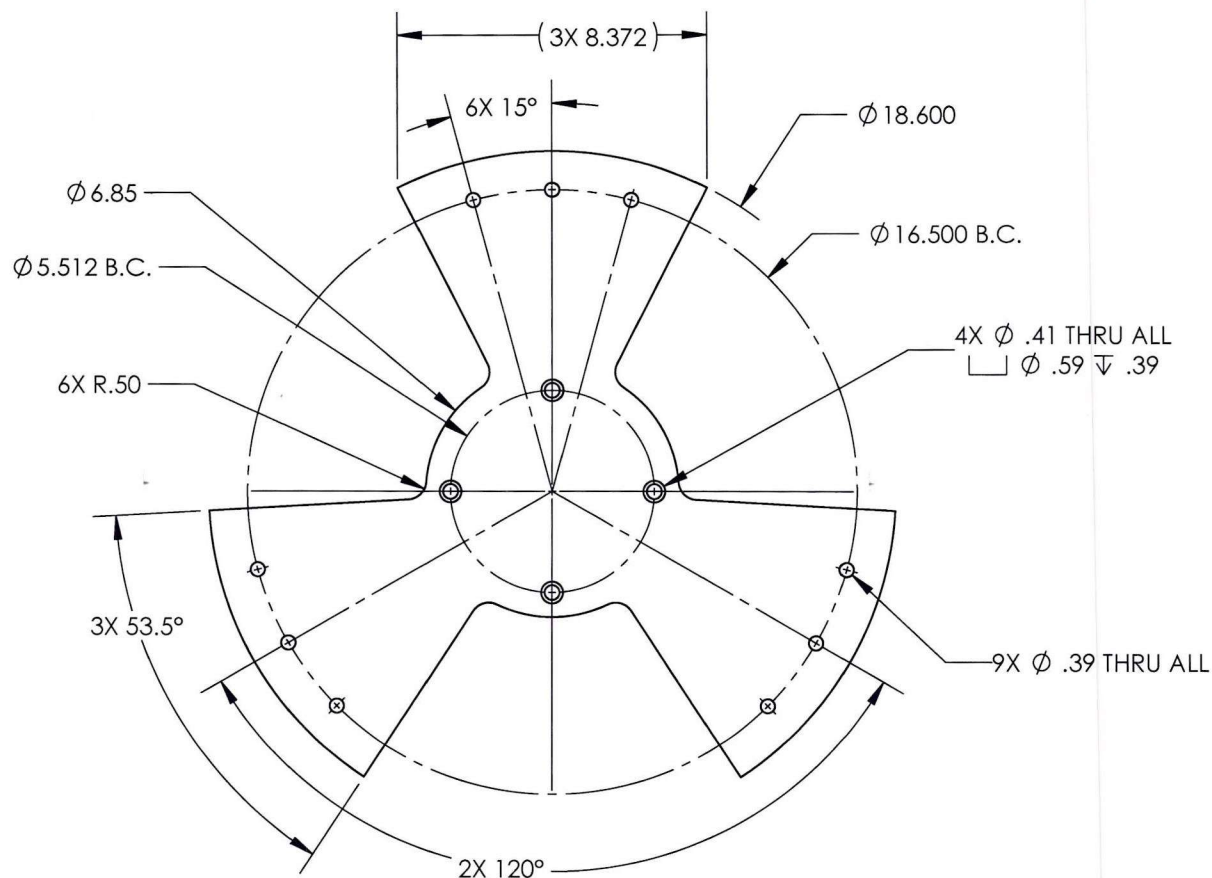
DWG NO. RBW6205G09132-3G REV 3

MAT'L	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Well</i>
.XXX $\pm$.005	HEAT TREAT FINISH
.XX $\pm$.01	FRACTIONS $\pm$ 1/8
.X $\pm$.1	ANGLES $\pm$ 5°
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AW139

SCALE 1:8 DATE 1/19/2012 SHEET 1 OF 9

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		-1 CH'D COUNTERBORE WAS .594 ∇ .390 IS .594 ∇ .39	6/25/2013	BIM
2		-1 CH'D COUNTERBORE HOLES FROM $\varnothing$ 5.375 B.C. TO $\varnothing$ 5.512 B.C.	7/12/2013	RJC

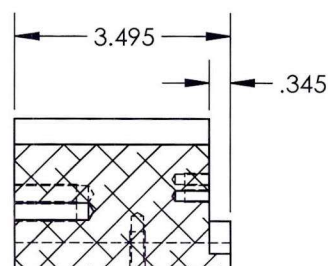
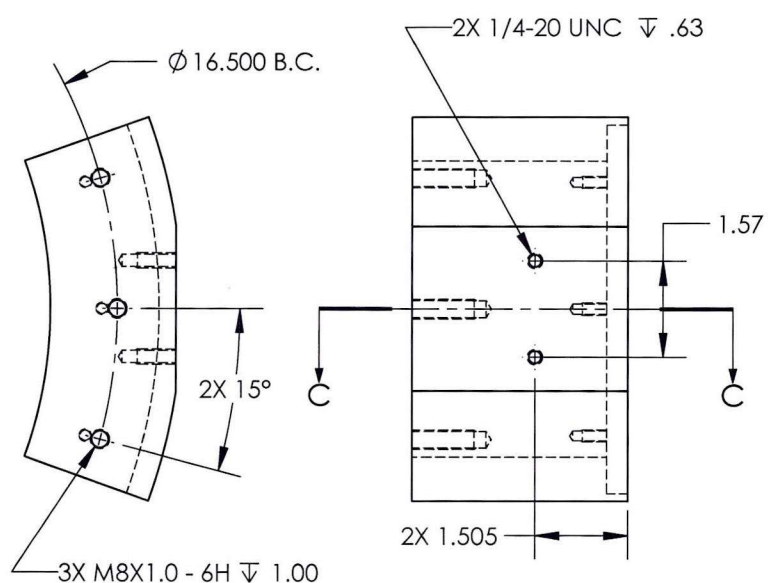


(-1)
BASE

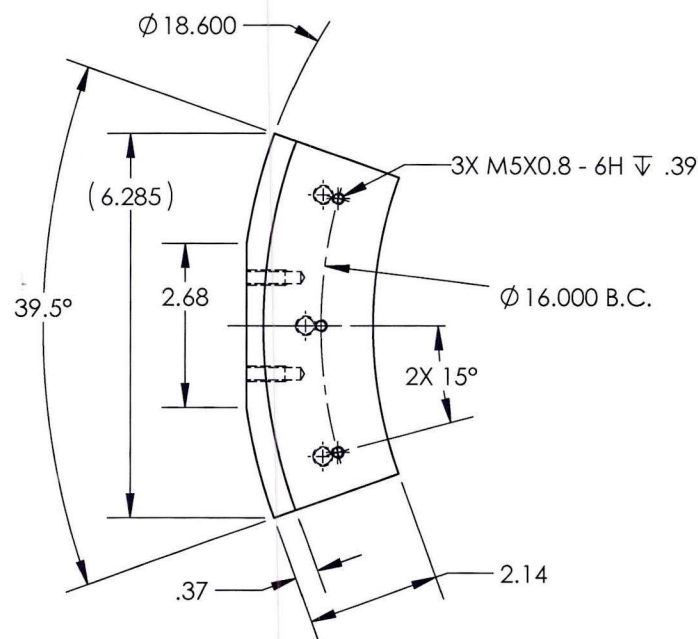
DART AEROSPACE	
TITLE TROLLEY ADAPTER, SWASHPLATE SUPPORT	
DWG NO. RBW6205G09132-3G-1	REV 3
MAT'L 6061	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX $\pm$.005 .XX $\pm$.01 .X $\pm$.1	HEAT TREAT FINISH CLEAR ANODIZE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC MIL-A-8625F, TYPE II, CLASS I
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AW139
SCALE 1:5	DATE 1/19/2012
SHEET 2 OF 9	

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			REVISIONS			
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
1		-3 CH'D HOLE DEPTHS WAS .394 IS .39, WAS 1.000 IS 1.00, WAS .625 IS .63.	6/25/2013	BIM	GE	



SECTION C-C

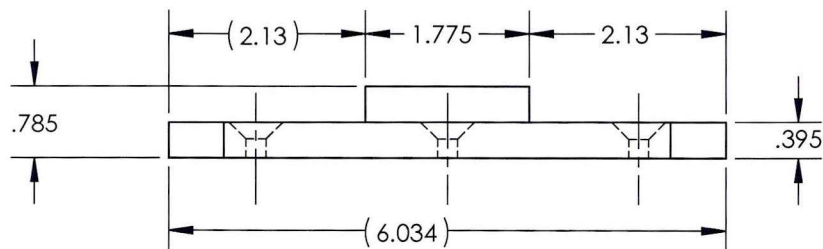
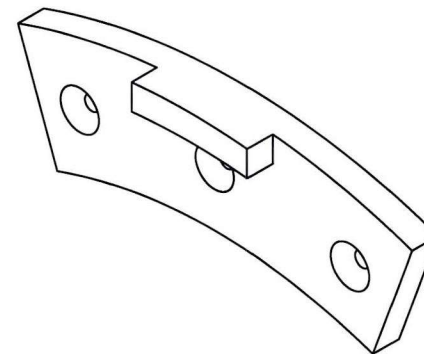
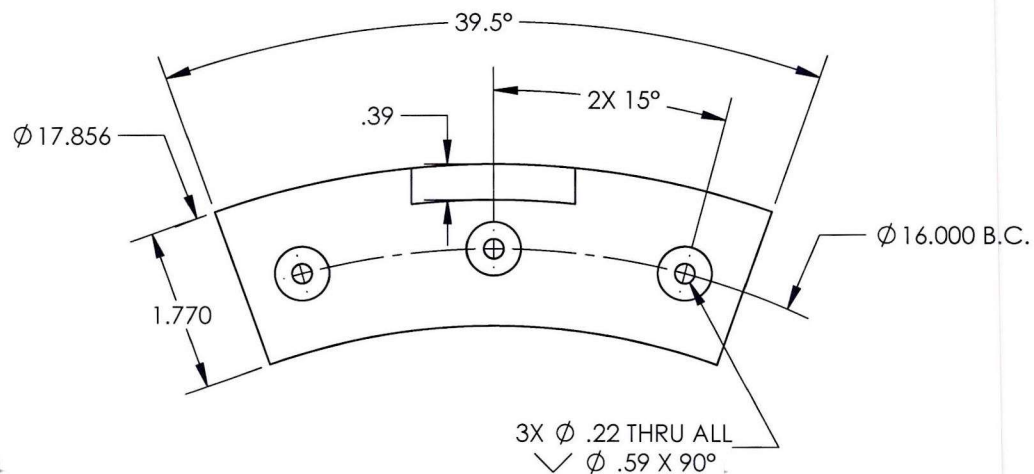


③
BLOCK

DART AEROSPACE	
TITLE TROLLEY ADAPTER, SWASHPLATE SUPPORT	
DWG NO. RBW6205G009132-3G-3	REV 3
MAT'L 6061	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005 .XX ± .01 .X ± .1	HEAT TREAT FINISH CLEAR ANODIZE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC MIL-A-8625F, TYPE II, CLASS I
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AW139
SCALE 1:3	DATE
SHEET 3 OF 9	

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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED



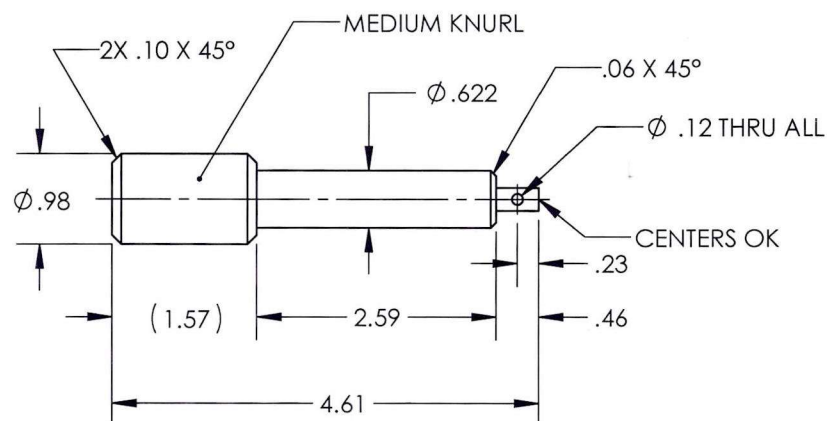
(-5)

WEAR PLATE

DART AEROSPACE	
TITLE TROLLEY ADAPTER, SWASHPLATE SUPPORT	
DWG NO. RBW6205G009132-3G-5	REV 3
MAT'L WHITE NYLON	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 .XX ± .01 .X ± .1	FRACTIONS ± 1/8 ANGLES ± 5°
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL AW139
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 1/19/2012 SHEET 4 OF 9

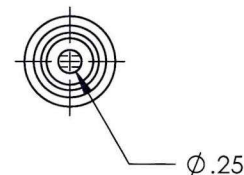
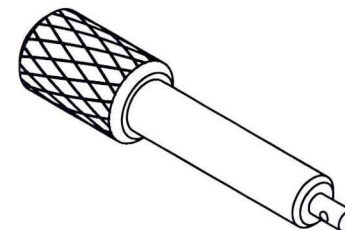
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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
1		-7 ADDED NOTE "CENTERS OK".		6/25/2013	BIM	GE



(-7)

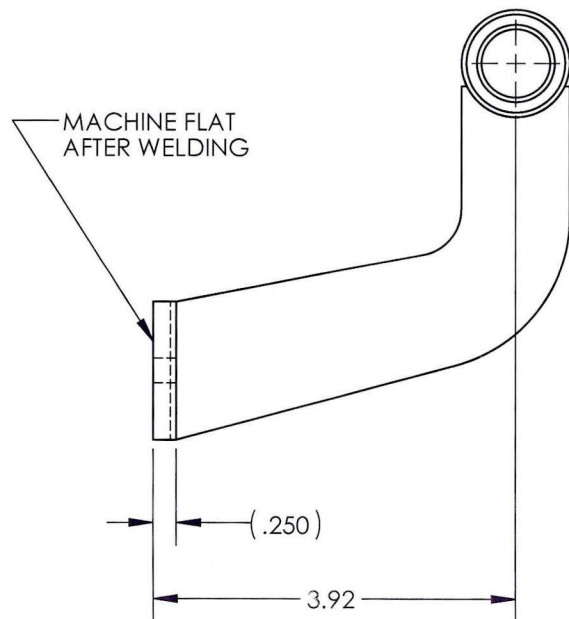
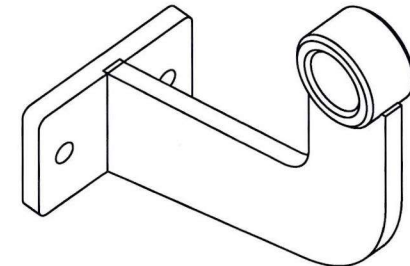
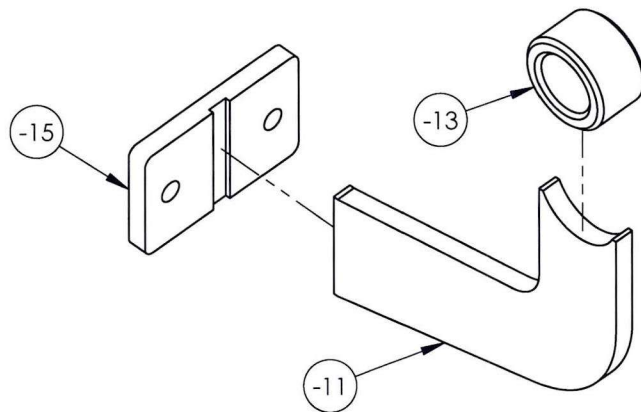
PIN



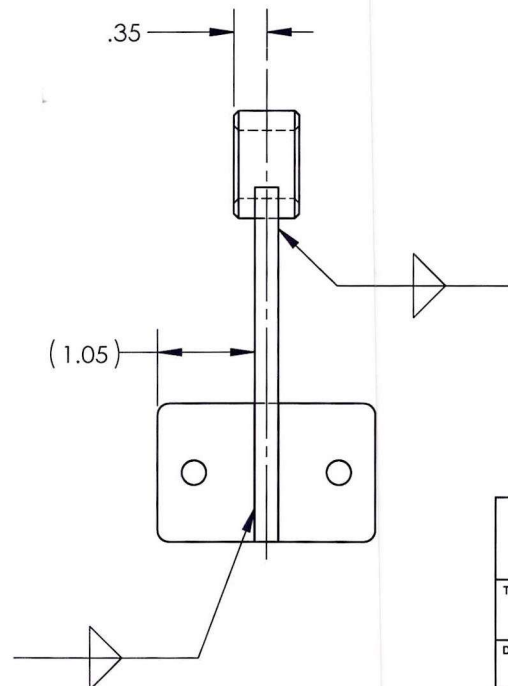
DART AEROSPACE	
TITLE TROLLEY ADAPTER, SWASHPLATE SUPPORT	
DWG NO. RBW6205G09132-3G-7	REV 3
MAT'L 6061	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005	HEAT
.XX ± .01	TREAT
.X ± .1	FINISH
FRACTIONS ± 1/8	CLEAR ANODIZE
ANGLES ± 5°	SPEC MIL-A-8625F, TYPE II, CLASS I
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AW139
SCALE 1:2	DATE 1/19/2012
SHEET 5 OF 9	

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			REVISIONS			
REV	ECR		DESCRIPTION	DATE	INITIAL	APPROVED
3	14-0154	-9 CH'D DIM FROM 4.164 TO 3.92.		9/19/2014	JAG	DW



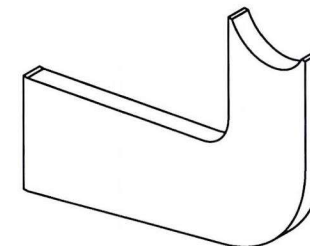
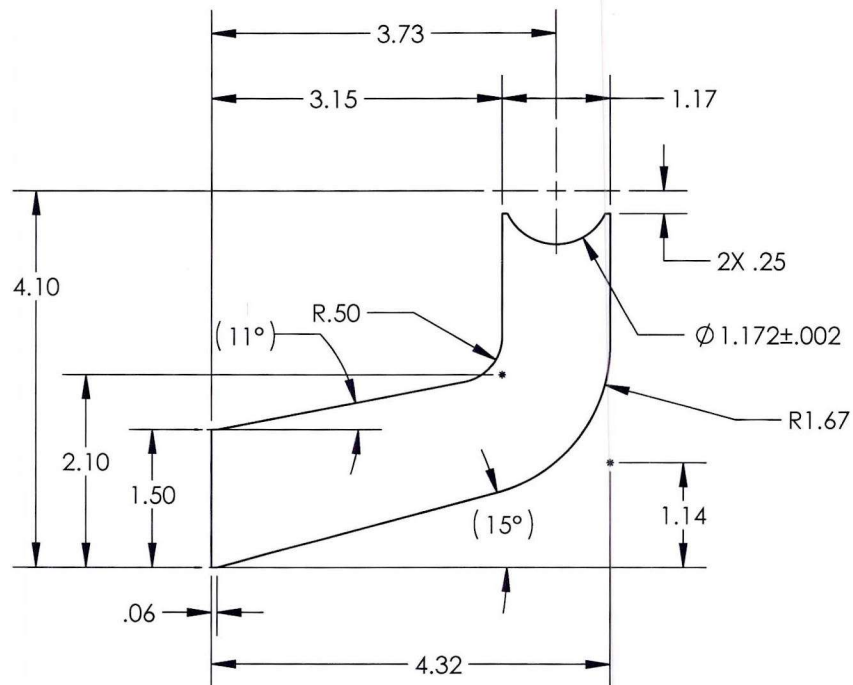
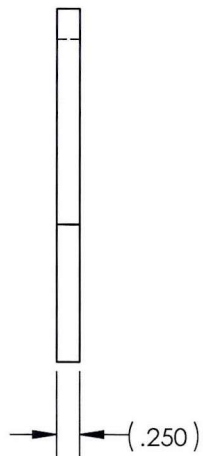
-9
ARM WELDMENT



DART AEROSPACE	
TITLE TROLLEY ADAPTER, SWASHPLATE SUPPORT	
DWG NO. RBW6205G09132-3G-9	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: GILBERT APPROVED: <i>D Well</i> HEAT TREAT FINISH CAD PLATE YELLOW
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC QQ-P-416F, TYPE II, CLASS II USED ON MODEL AW139
SCALE 1:2	DATE 1/19/2012 SHEET 6 OF 9

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
3	14-0154	-11 CH'D DIM FROM 4.562 TO 4.32.			9/19/2014	JAG DW

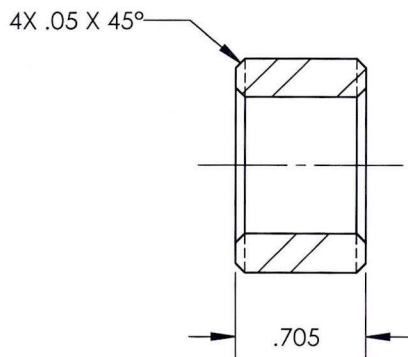


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ARM

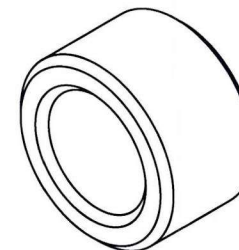
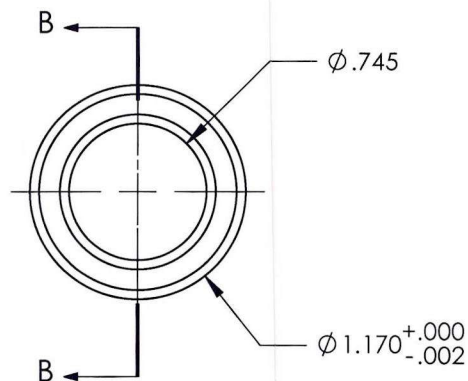
DART AEROSPACE	
TITLE TROLLEY ADAPTER, SWASHPLATE SUPPORT	
DWG NO. RBW6205G09132-3G-11	REV 3
MAT'L 1018	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH SEE -9 WELDMENT
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AW139
SCALE 1:2	DATE 1/19/2012
SHEET 7 OF 9	

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
1		-13 CH'D CHAMFER WAS 4X .050 X 45° IS 4X .05 X 45°.			6/25/2013	BIM GE



SECTION B-B



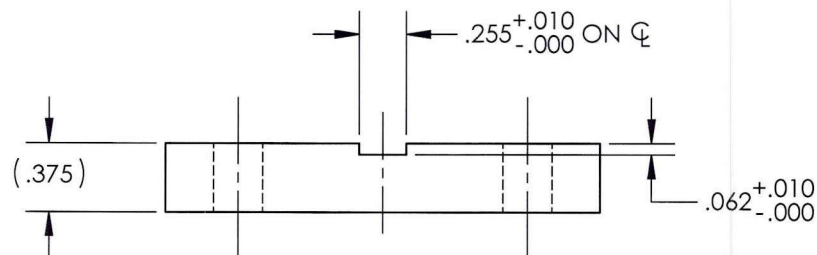
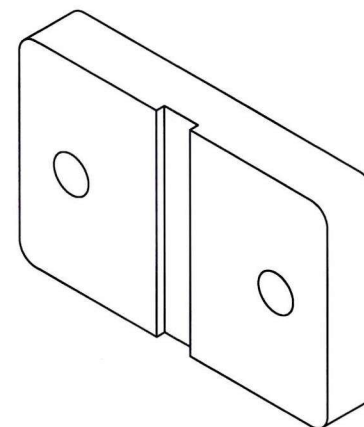
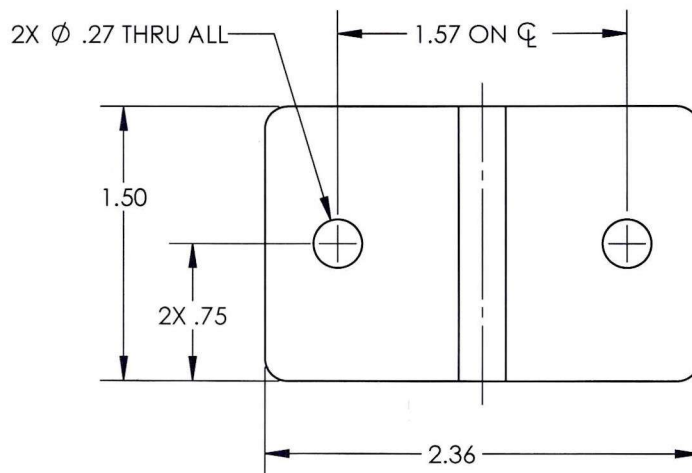
(-13)

RING

DART AEROSPACE	
TITLE TROLLEY ADAPTER, SWASHPLATE SUPPORT	
DWG NO. RBW6205G09132-3G-13	REV 3
MAT'L 1018	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT
.XX ± .01 ANGLES ± .5°	TREAT
.X ± .1	FINISH SEE -9 WELDMENT
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AW139
SCALE 1:1	DATE 1/19/2012 SHEET 8 OF 9

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



(-15)

PLATE

DART AEROSPACE	
TITLE TROLLEY ADAPTER, SWASHPLATE SUPPORT	
DWG NO. RBW6205G09132-3G-15	REV 3
MAT'L 1018	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT
.XX ± .01 ANGLES ± 5°	TREAT
.X ± .1	FINISH SEE -9 WELDMENT
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AW139
SCALE 1:1	DATE
SHEET 9 OF 9	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041054

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Ship To:

PO No: PO041054
PO Date: 9/18/18
Due Date: 10/9/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, Patrick
Phone:
Pynt Terms: Net 30
Freight Terms:
Special Comments: *Revision*

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	183473	RBW6505G00151-3GP			Lift Eye Tail Rotor Gear Box	Firmed	-	10/9/18	4 Ea	0 Ea	4 Ea	\$214.54/Ea	\$858.16
Line Item Note REV 2													
2	183474	RBW6205G09132-3GP			Trolley Adapter, Swashplate Support	Firmed	-	10/9/18	2 pcs	0 pcs	2 pcs	\$2,698.00/pcs	\$5,396.00
Line Item Note REV 3													
Grand Total:												\$6,254.16	

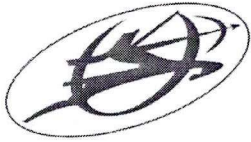
Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/28/18 9:06 AM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 278

Date: 10/8/2018 ✓
PO: 041054 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
2 ✓	TROLLY ADAPTER, SWASHPLATE SUPPORT ✓	RBW6205G09132-3G REV-3

DAS
38
9-89

Received by: _____
Packaged by: G.E. _____
Checked by: [Signature] _____

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:041054 ✓

Dated: 10/08/2018

Our Order / Job No:091818 DAWT

Order Qty:2 ✓

Part Name: TROLLY ADAPTER, SWASHPLATE SUPPORT

Part Number: RBW6205G09132-3G ✓

Lot Size:N/A Ship Date: 10/08/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number:RBW6205G09132-3G

Rev:3

Material Size and Type: 6061, WHITE NYLON, 1018

Material Specifications: ASTM B221, ASTM D5989, ASTM A108 , ASTM A29,

Heat Treatment:N/A

Plating/Finish: MIL-A-8625F, TYPE II, CLASS I ZINC PLATE ASTM B633 TYPE I SC 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 10/08/2018

Signed: Hernan M. Salas

DAS
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